

Work Order ID 58967

Thursday, May 20, 2010 12:35:57 PM



Page 1

Item ID: D3552-11

Accept



Setup Start



Revision ID:

Item Name: Door Prop

Stop



Start Date: 5/20/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 5/31/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 10-5-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr Revision Nbr

D3552

Rev E

100



PURCHASING

Purchasing

Memo

0.00

CZ 10/5/20 12

Purchasing

Issue P/O: 11950

Purchase Part Number: B8-240-575-150N

Supplier: LS Technologies

Certificate of conformity is required

110



Receive & Inspect for Damage & Mat'l Certs

0.00

PC 10/6/3 CZ

Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

120



QC6- Inspect dimensions to drawing

0.00

Sustoloy

T/12

QC

Quality Control

Memo

0.00

Test for correct pressure

Tested at 48 lbs.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, May 20, 2010 12:36:02 PM

Page 1

Work Order ID: 58967



Parent Item: D3552-11



Parent Item Name: Door Prop

Start Date: 5/20/2010

Required Date: 5/31/2010

Comments: IPP Rev:B 09-04-20 rev.d as per dwg DD verified by:EC
as per dwg RevE DD 10.02.17 verified by:EC

IPP Rev:C

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
B8-240-575-150N			No			110	Each	0.0000	1		5/20/13	12

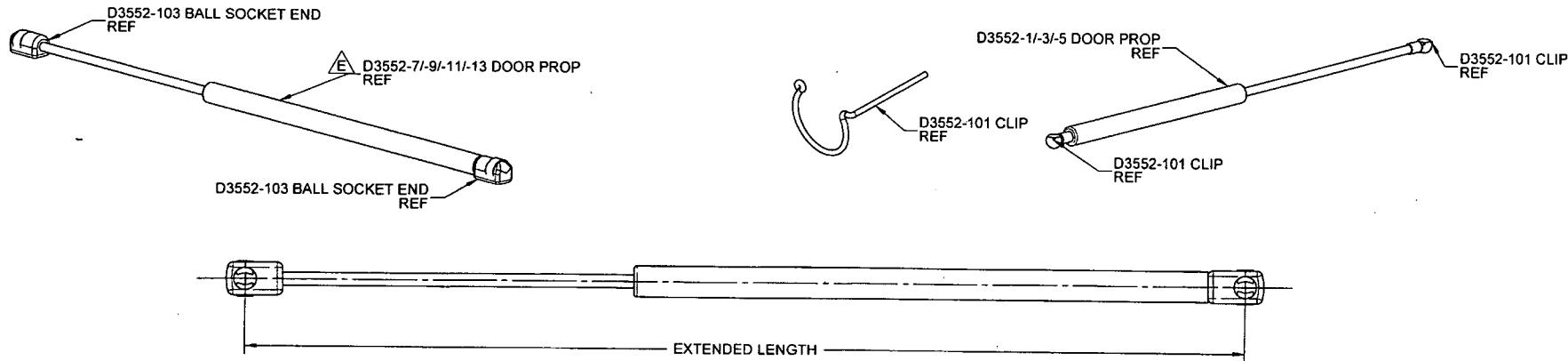
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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SPECIFICATION CONTROL DRAWING



DART PART NUMBER	DESCRIPTION	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	FORCE (N/lb)	END FITTING	MATERIAL	SUPPLIER	SUPPLIER PART NUMBER
D3552-1	DOOR PROP	220/8.66	530/20.6	70/15.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-220-530-070N
D3552-3	DOOR PROP	200/7.87	490/19.3	200/45.0	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-200-490-200N
D3552-5	DOOR PROP	175/6.89	430/16.9	150/33.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-175-430-150N
D3552-7	DOOR PROP	220/8.66	530/20.9	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-220-530-070N
D3552-9	DOOR PROP	200/7.87	490/19.3	200/45.0	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-200-490-200N
D3552-11	DOOR PROP	240/9.45	575/22.6	150/33.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-240-575-150N
D3552-13	DOOR PROP	220/8.66	530/20.9	140/31.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-220-530-140N
D3552-101	CLIP	N/A	N/A	N/A	N/A	CARBON STEEL	LS TECHNOLOGIES	C9
D3552-103	BALL SOCKET END	N/A	N/A	N/A	N/A	NYLON	LS TECHNOLOGIES	B10

RELEASED
R 2000-10-10

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
No: 58767 2010-5-20

D3552-X DOOR PROP

NOTES:
 1) IDENTIFICATION: IDENTIFY WITH DART P/N "D3552-X" AND B/N USING WHITE FINE POINT PERMANENT INK MARKER
 2) D3552-101 CLIP IS ONLY COMPATIBLE WITH D3552-1/3-5 DOOR PROPS
 3) D3552-103 BALL SOCKET END IS ONLY COMPATIBLE WITH D3552-7/9-11-13 DOOR PROPS

E	ADD P/N D3552-13 ZN B8-1, A8-1, D6-1, CHANGE NAME FROM "GAS SPRING" TO "DOOR PROP" THROUGH OUT DWG			<u>AS</u>	10.02.03
D	ADD P/N D3552-101 ZN D6-1, C7-1, C1-1 AND D3552-103 ZN D1-1 AND C2-1 AND ZN B8-1; ADD NOTE REGARDING D3552-101 AND D3552-103 COMPATIBILITY ZN A8-1			HS	09.04.02
C	ADD D3552-11 AND CONVERSIONS FOR INSPECTION; UPDATE P/N FOR D3552-7			LE	07.06.01
B	ADD D3552-7/9; UPDATE DESC. D3552-1/3/5			LE	06.10.24
A	NEW ISSUE			LE	06.09.15
REV.	DESCRIPTION	BY	DATE		
DESIGN	<u>AS</u>	DART AEROSPACE LTD			
DRAWN	<u>AS</u>	HAWKESBURY, ONTARIO, CANADA			
CHECKED	<u>AS</u>	DRAWING NO.			REV. E
MFG. APPR.	<u>AS</u>	D3552			SHEET 1 OF 1
APPROVED	<u>AS</u>	TITLE			SCALE
DE APPR.	<u>AS</u>	DOOR PROP			NTS
DATE	10.02.03				

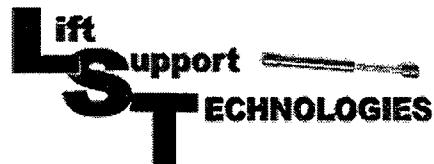
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NOTE: Date & initial all entries



303 – 103rd Street, Saskatoon, Saskatchewan, Canada S7N 1Y9
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

12 Units: B8-240-575-150N Gas Spring Carbon Steel

Country of Manufacture: Canada

Date of Manufacture : May 2010

This product is ROHS compliant.

*S
10/06/09*

We certify no mercury was used in the manufacture of this order.

Purchase Order #11950

Invoice # 6171

L S Technologies Inc Canada


Nolan Fehr
Manager